

Date: Thursday, 31/07/2008 2:26:36 PM  
User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: UPPER RAIL
Job Number	: 40866 - 3	Part Number	: D37671
Estimate Number	: 13489	Drawing Number	: D3767 REV B
P.O. Number	:	Project Number	: N/A
This Issue	: 31/07/2008 S.O. No. :	Drawing Revision	: B
Prsht Rev.	: NC	Material	:
First Issue	: 31/07/2008 Type : SMALL /MED FAB	Due Date	: 08/08/2008
Previous Run	: 40711	Qty:	76 Um: Each
Written By	:		
Checked & Approved By	: <u>JUD 08.8.01</u>		
Comment	: Est Rev:A 08-07-21 revB as per dwg DD verified by:EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6T1000W065	6061T6 RD TUBE 1.00 x .065w
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Comment: Qty.: 2.9313 f(s)/Unit Total: 46.9006 f(s)

6061T6 TUBE (1.00" x 0.65" wall)

batch: M102 877

SAD 08/08/14

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

1-cut tube to length as per dwg D3767

QH/SAD 08/08/25

2-drill holes thru to finish size as per dwg D3767

FF 08/09/18 (2x) 16x

3- deburr

08/08/25

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

08/08/17 (x2)

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M- 08/09/19

5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-09-19 (x2)



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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: UPPER RAIL

Job Number: 40866

Part Number: D37671

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SS 08/09/19 (2)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



08/09/19

Comment: FINAL INSPECTION/W/O RELEASE

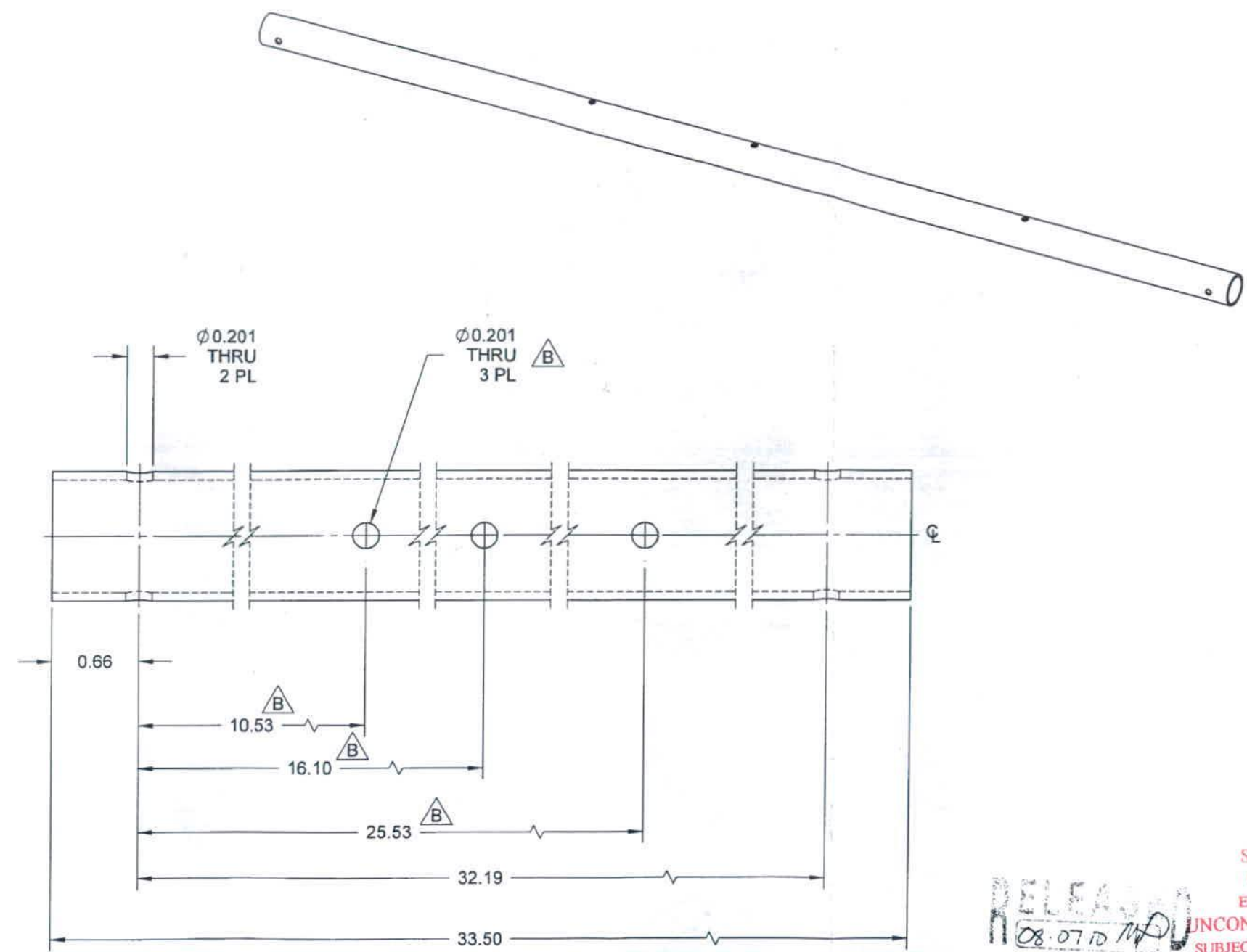
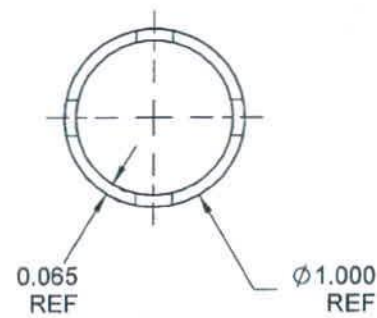
Job Completion



MF 08-09-19







**D3767-1 UPPER RAIL**

**NOTES:**

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.00" OD X 0.065" WALL) PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR AMS-QQ-A-225/8 (REF. DART SPEC. M6061T6T1.000W.065)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.62 lbs

B	CHANGE HOLE SIZE TO 0.201, SHIFT HOLES FOR ATTACHING FRAME BY 0.125, ADD HOLE AT 16.10	HS	08.06.23
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3767	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		UPPER RAIL	NTS
DATE	08.06.23	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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NO. 40866-2

